

Date: Tuesday, 3/20/2007 1:53:27 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT X-TUBE EXT HEIGHT(-013)
Job Number	: 31379		
Estimate Number	: 10563		
P.O. Number	: <i>N/A</i>	Part Number	: D205596107
This Issue	: 3/20/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D205596107
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : LANDING GEAR	Drawing Revision	: A
Previous Run	: 31378	Material	: <i>N/A</i>
Written By	: _____	Due Date	: 4/15/2007 Qty: 1 Um: Each
Checked & Approved By	: <i>KJ 07.03.20</i>		
Comment	: Est Rev: D 05.03.21 Added bending procedure KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL
Photocopy D205-594 bluefile & type labels per PPP D205-596-107CHG001

KJ 07.04.03 (1)

2.0	D2890	Aft Crosstube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:
Qty Part number Description Batch
1 D2890 Aft Crosstube *31370*

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1
Mark 20.36" for cutting from tangential line in the straight section from D2890 as per Dwg wall template.

DP 7-4-11

4.0	QC15	DIMENSIONAL CHECK OF X-TUBES
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Comment: DIMENSIONAL CHECK OF X-TUBES

20704.11 0

5.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut as per Dwg D205-596-107

DP 7-4-11

2-Deburr & Inspect for surface damage. Polish cut surface. Scribe part # and batch # on one end of tube.

JB 7-4-11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/20/2007 1:53:27 PM
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Drawing Name: AFT X-TUBE EXT HEIGHT-(013)

Job Number: 31379

Part Number: D205596107

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC15

DIMENSIONAL CHECK OF X-TUBES

QC5



07-04-23 @



Comment: DIMENSIONAL CHECK OF X-TUBES

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up ends of the tube with Chemical Conversion Coat per QSI 005 4.1

00 7-4-13

8.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside with Immron per QSI 005 4.2

ml 07 07 24

9.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

RT 07-07-25

10.0

D2856600

Abrasion Strip



Comment: Qty.: 1.6810 f(s)/Unit Total : 1.6810 f(s)

Pick:

Qty Part number

Description

Batch

2 D2856-600(10.09") Abrasion Strip

26650

RT 07-07-25

11.0

D29401

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number

Description

Batch

2 D2940-1

Support

24367

RT 07-07-25

12.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number

Description

Batch

4 MS21920-28

Clamp

103896

RT 07-07-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: R Date: 07/08/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT X-TUBE EXT HEIGHT(-013)

Job Number: 31379

Part Number: D205596107

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips per QSI 035 position using DT8582. Install supports and clamps per Dwg D205-596-107. Torque clamps to 80-100 in lb. Seal edges of support using Sikaflex

BT 07-07-25

A/R Sikaflex -291

NA

Expiry date:

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 07/07/31

(41)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-596-107

Location:

PPP Rev:

Rec C

7/8/1

SPL

16.0

QC21

FINAL INSPECTION/W/O RELEASE



(1)

Comment: FINAL INSPECTION/W/O RELEASE

Er 07/08/01

Job Completion



Er 07-08-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

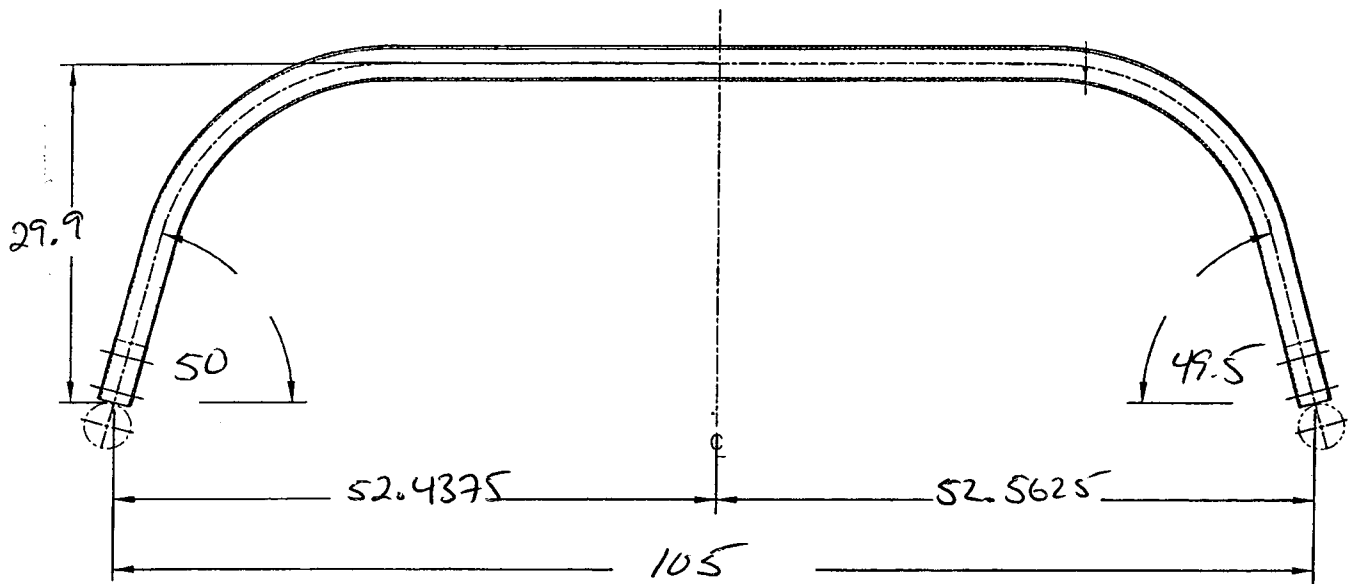
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	31379
Description: Crosstube High-High Aft		Part Number:	D205-596-107
Inspection Dwg: D205-596-107 Rev: A		Page 1 of 1	

Required Dimension	Min	Max
Height	29.7	29.9
1/2 Span	52.4	52.6
Angle	49	52
Total Span	104.8	105.2

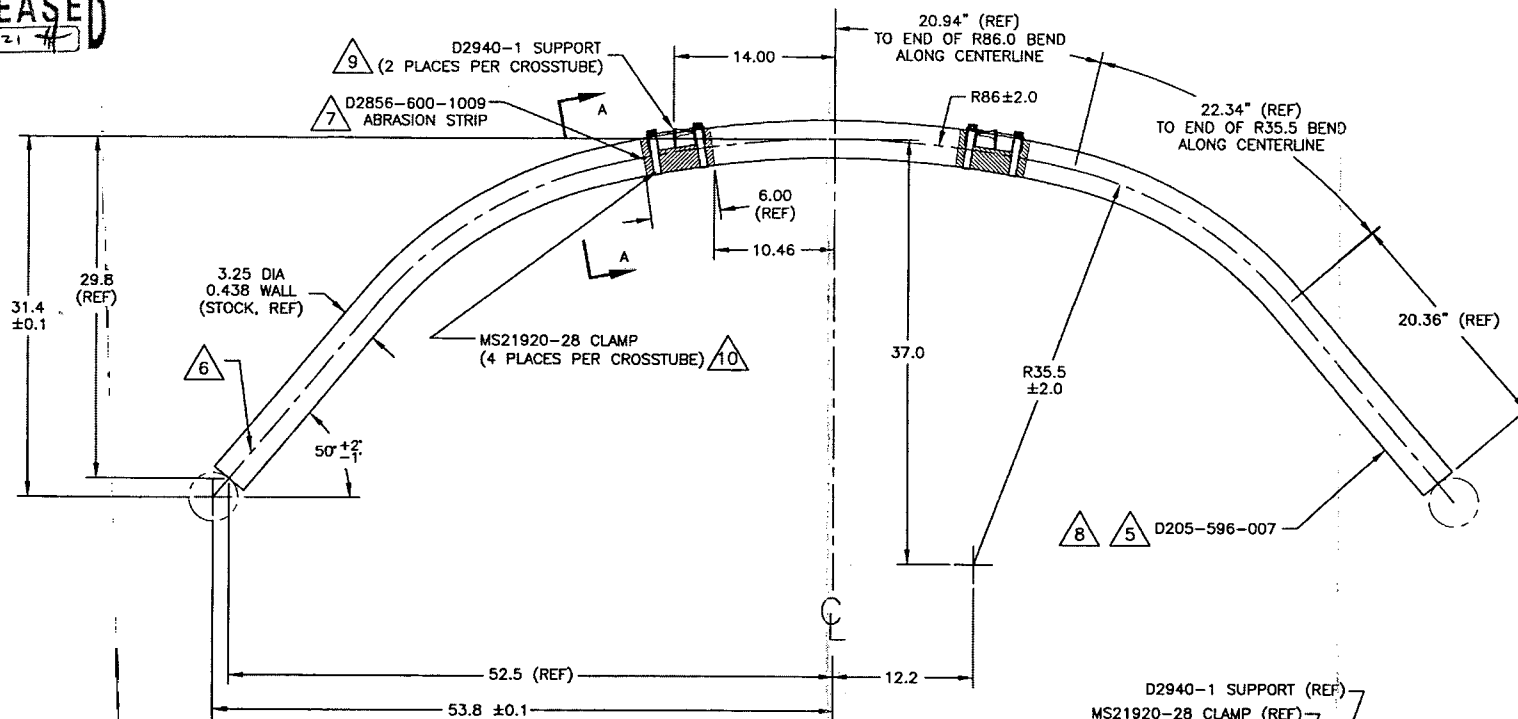


Comments

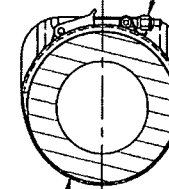
QC15 Inspection	<i>[Signature]</i>
Date	070411

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM <i>[Signature]</i>	<i>[Signature]</i>

RELEASED
02.11.21



D2940-1 SUPPORT (REF)
MS21920-28 CLAMP (REF)



SECTION A-A
SCALE 2:5

D2856-600-1009 ABRASION STRIP (REF) 7

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURE FROM D6008-180
FINISHED LENGTH = 127.28
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 6) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS
- 7) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2940-1 SUPPORT, PER QSI 035
- 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005\" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 9) SEAL EDGES OF SUPPORTS USING SIKAFLEX-241/-291 SEALANT (OPTIONAL)
- 10) TORQUE CLAMPS 80 TO 100 IN-LB

NO
31379
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

A		02.11.20	NEW ISSUE
DESIGN	✓	DRAWN BY	DART
CHECKED	✓	APPROVED BY	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
DATE	02.11.20	DRAWING NO.	D205-596-107
		TITLE	CROSSTUBE AFT EXTENDED
		SCALE	1:10

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